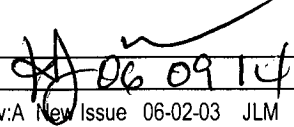


Date: Thursday, 9/14/2006 7:31:04 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	TUBE
<b>Job Number</b> :	28590		
<b>Estimate Number</b> :	12171		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D34767
<b>This Issue</b> :	9/14/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3476 REV A
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	27026	<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	N/A
	SMALL / MED FAB	<b>Due Date</b> :	10/6/2006
<b>Written By</b> :			<b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est Rev:A New Issue 06-02-03 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



**Comment:** Qty.: 0.1072 sf(s)/Unit Total : 0.8576 sf(s)

Pick:

304/316 0.018 SHEET

(M304S26GA)

Batch: 17101000

FF 06.09.15 8

2.0	SHEAR	SHEAR
-----	-------	-------

**Comment:** SHEAR

Cut Flat pattern 1.66" X 8.75" as per Dwg D3476 ?

FF 06.09.15 8

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Roll as per Dwg D3476

3-Form Bead as per Dwg D3476 Using Rotary Machine.

4-Spot Weld as per Dwg D3476 and Dart QSI 018

5-Cut 69 Deg Angle as per Dwg D3476.

FF 06.09.18 8

SB 06/09/19 8

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: DP Date: 06/09/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 9/14/2006 7:31:04 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 28590

Part Number: D34767

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

AA06/09/26 (8)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

I.D. And stuck

06/09/27 (8)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/09/27 (8)

Job Completion



W 06.09.27

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-05-26	S.O	I.D. i stock in Location <u>22</u> from change. <u>2</u>	<u>EE</u>	06-10-04			<u>2</u> 06-05-26

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

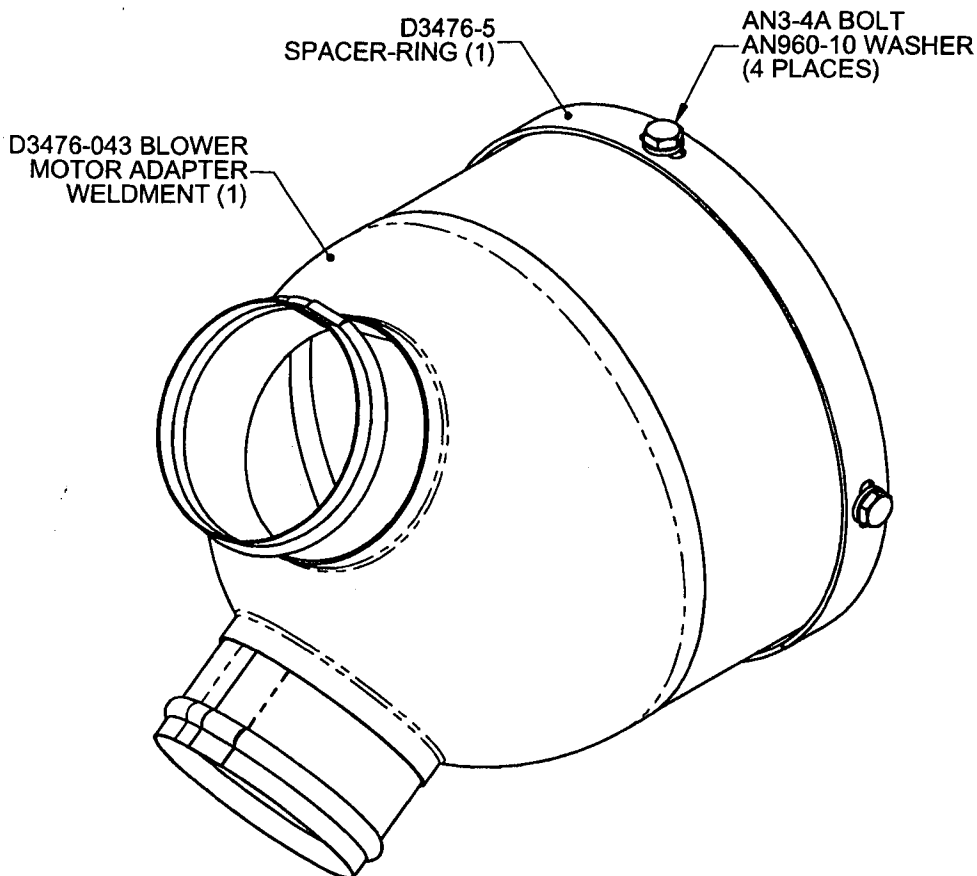
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3476</b>	REV. A SHEET 1 OF 7
DATE <b>06.01.27</b>		TITLE <b>BLOWER MOTOR ADAPTER</b>	SCALE 1:2
A	06.01.27	NEW ISSUE	

*[Signature]* 06.04.03



### **D3476-041 BLOWER MOTOR ADAPTER**

- 1) IDENTIFY WITH DART P/N D3476-041 USING FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	D3476-041	BLOWER MOTOR ADAPTER
1	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-5	SPACER-RING
4	AN3-4A	BOLT
4	AN960-10	WASHER

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WITHOUT NOTICE  
WORK ORDER  
NO. **28590**

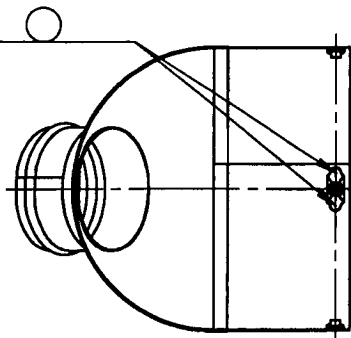
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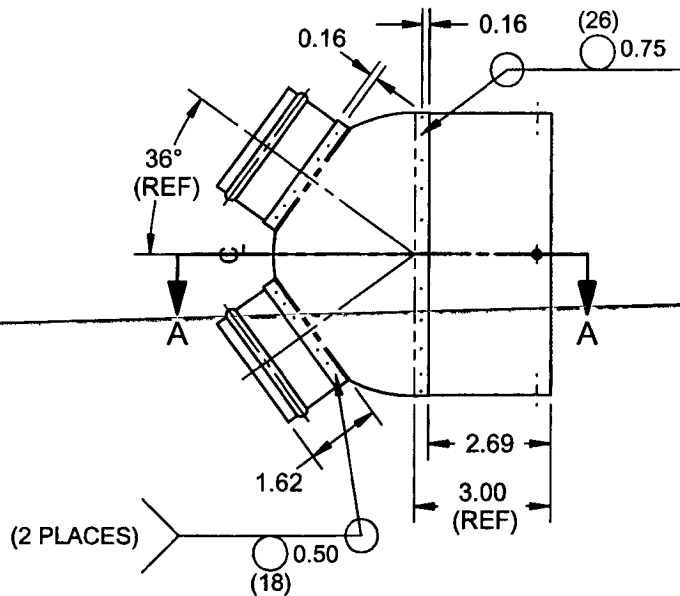
**DART**

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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3476</b>	REV. A SHEET 2 OF 7
DATE. <b>06.01.27</b>	TITLE <b>BLOWER MOTOR ADAPTER</b>		SCALE 1:4

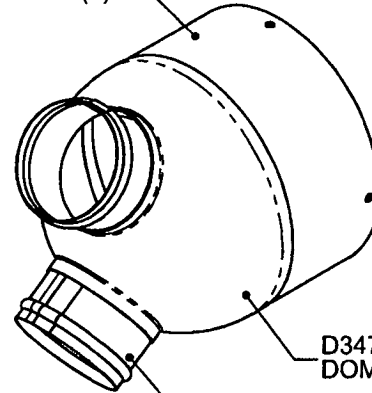
LOCATE AND  
SPOT WELD  
NUT PLATES  
(4 PLACES)



**SECTION A-A**



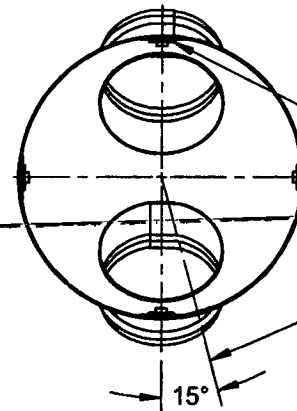
D3476-1  
DUCT (1)



D3476-3  
DOME (1)

D3476-7 TUBE  
(2 PLACES)

NAS-1031C3W  
NUT PLATES  
(4 PLACES)



OFFSET SEAM  
ON DUCT

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NO. 28590

**D3476-043 BLOWER MOTOR  
ADAPTER WELDMENT**

**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) PART IS SYMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-1	DUCT
1	D3476-3	DOME
2	D3476-7	TUBE
4	NAS1031C3W	NUTPLATE

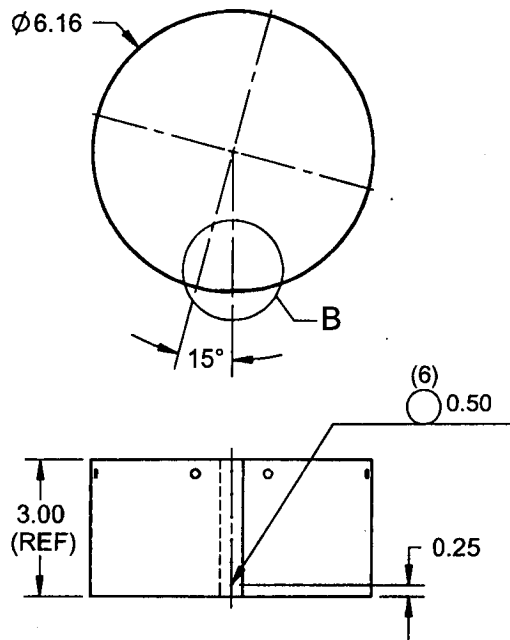
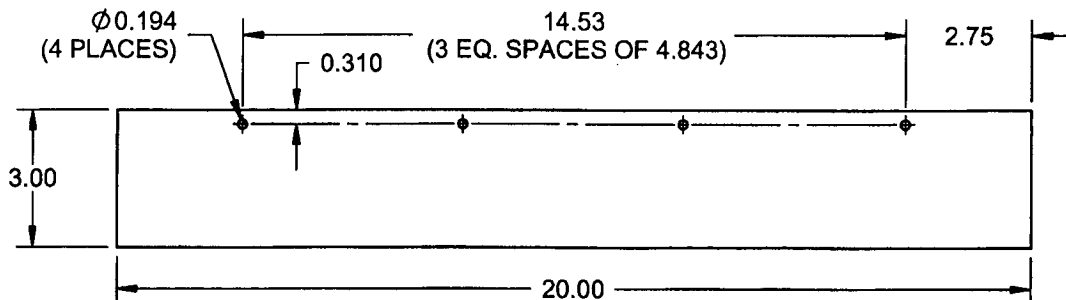
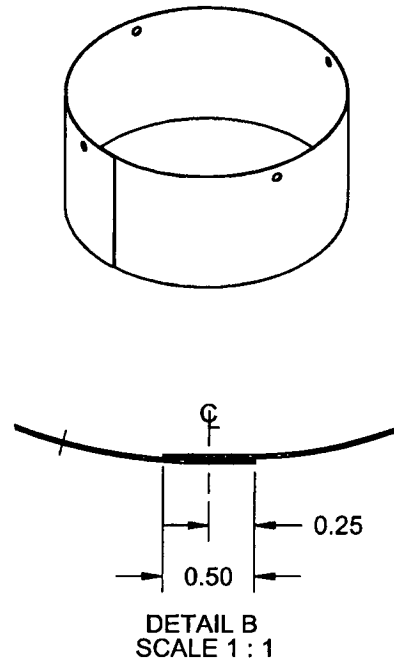
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DATE <b>06.01.27</b>		TITLE <b>BLOWER MOTOR ADAPTER</b>	SCALE 1:4

# 06.01.03

**D3476-1 DUCT****D3476-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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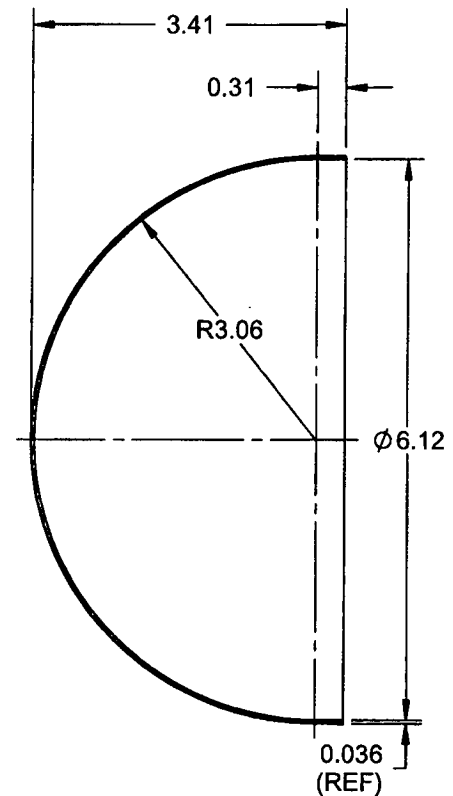
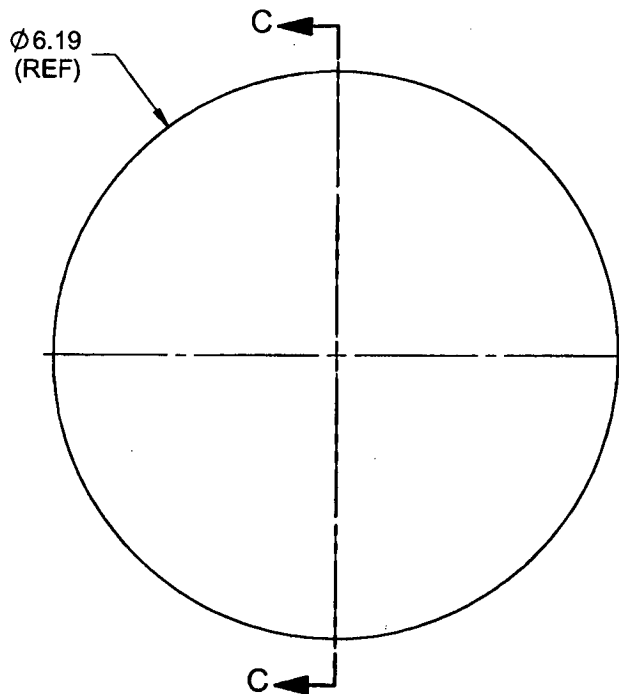
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

RELEASED

06.04.03 *[Signature]***SECTION C-C****D3476-3S DOME, SPINNING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.036 THICK PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S20GA)
- 2) FORM BY SPINNING TO DIMENSION WITHOUT EXCESS THINNING OF MATERIAL (MINIMUM THICKNESS = 0.025").
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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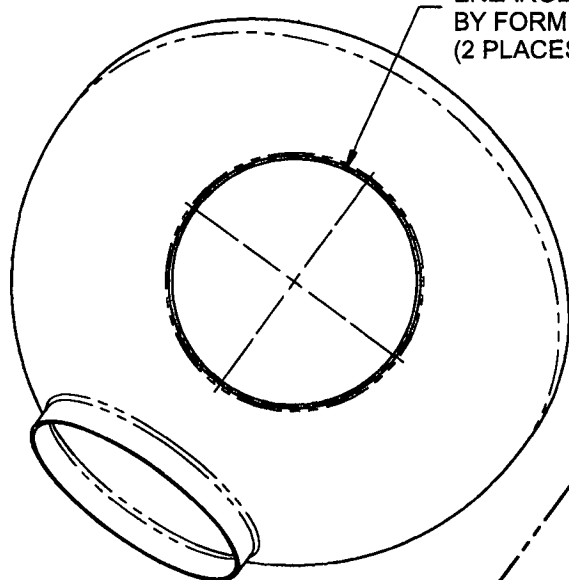




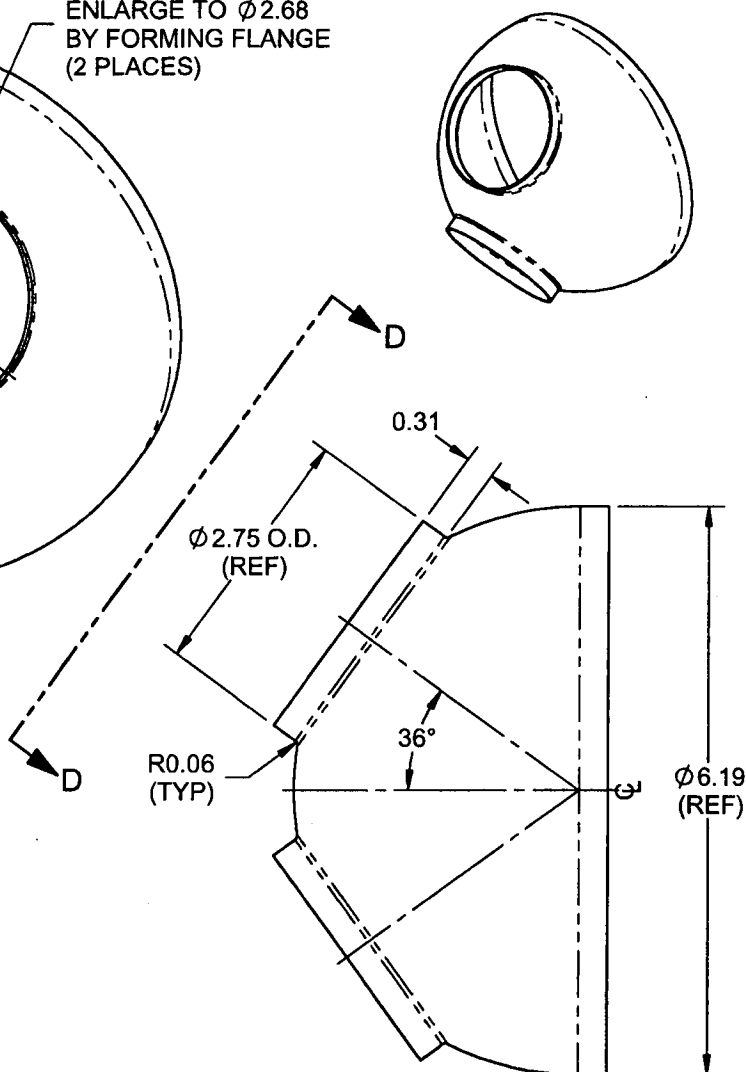
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

# 06.04.03

CUT  $\phi 2.25$  HOLE,  
ENLARGE TO  $\phi 2.68$   
BY FORMING FLANGE  
(2 PLACES)



VIEW D-D



### D3476-3 DOME

#### NOTES:

- 1) MATERIAL: MAKE FROM D3476-3S
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

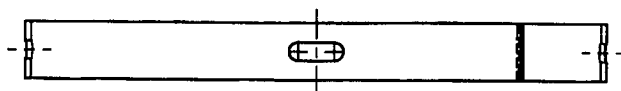
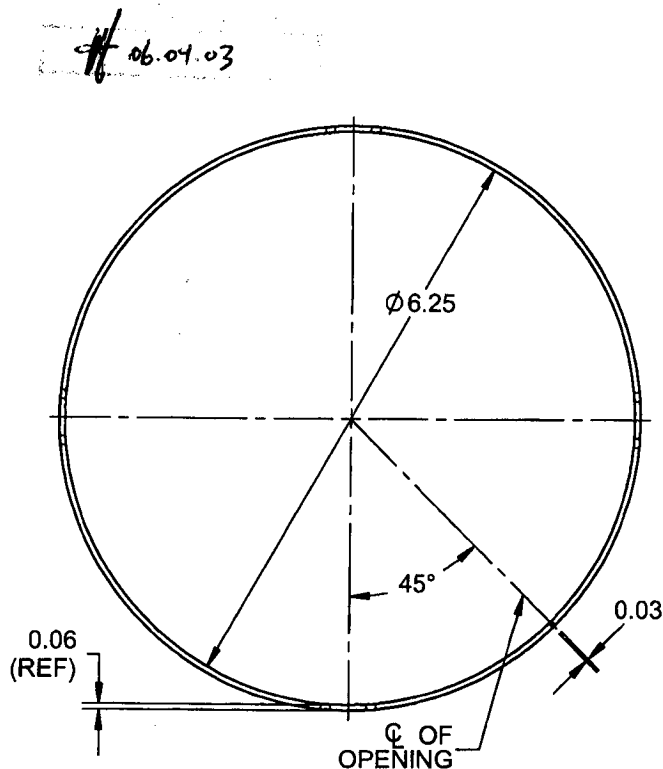
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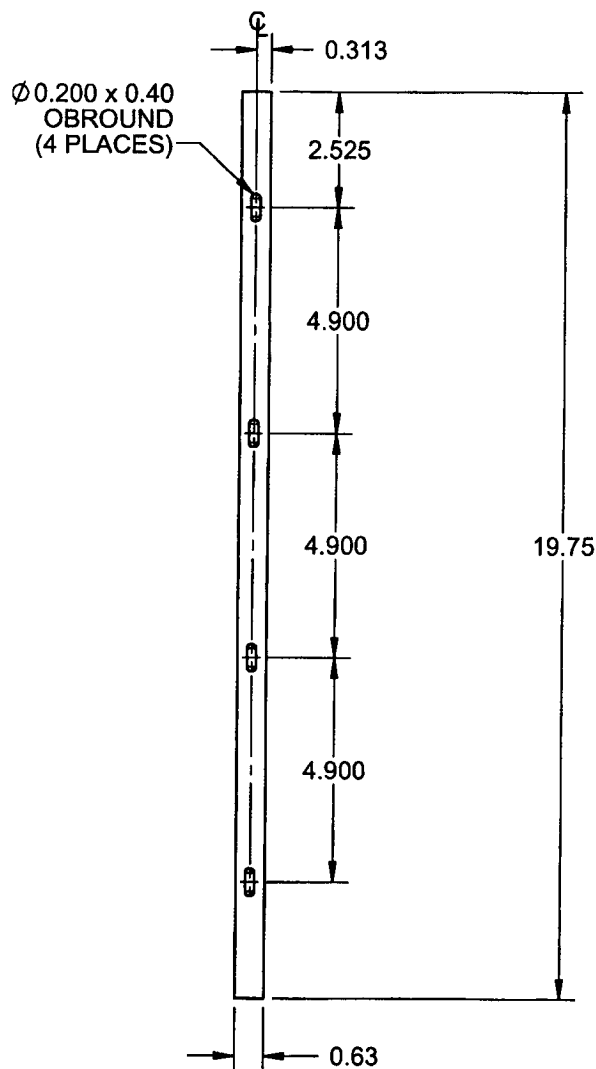
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2



**D3476-5 SPACER-RING**



**D3476-5F SPACER-RING  
FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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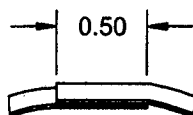
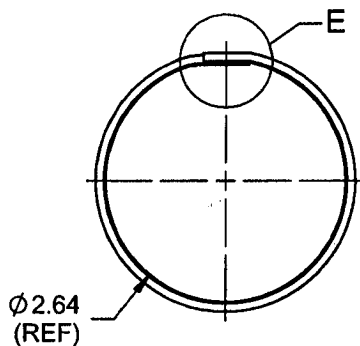
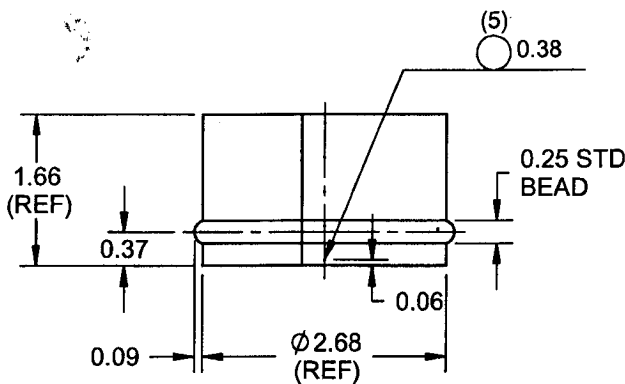
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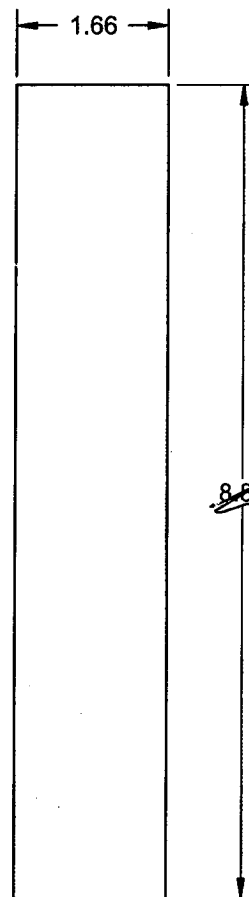
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3476</b>	REV. A SHEET 7 OF 7
DATE <b>06.01.27</b>		TITLE <b>BLOWER MOTOR ADAPTER</b>	SCALE 1:2

*[Handwritten]* 06.04.03



DETAIL E  
SCALE 1 : 1

**D3476-7 TUBE**



**D3476-7 TUBE  
FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 4

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Sylvie Boudier  
Joint Welding Procedure Spot welding  
Part number and Job number A34767 / B28590

TEST WELDS REQUIRED

BASE METAL Stainless Steel WELDING PROCESS Spot weld  
Penetration Complete ☒ Partial ☐ Single Weld ☒ Double Weld ☐  
Current AC ☐ DC ☒ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into \_\_\_\_\_ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☐ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/09/19 Qualifier Daniel Mural